


Date: Monday, 12/11/2007 9:42:49 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE BRACKET (407I)
Job Number : 35492	
Estimate Number : 11008	
P.O. Number : N/A	Part Number : D2608
This Issue : 12/11/2007 S.O. No. : N/A	Drawing Number : D2608 REV .A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A 1
Previous Run : 35492	Material : N/A
Written By : _____	Due Date : 05/12/2007
Checked & Approved By : _____	Qty:  Um: Each
Comment : Est. E 02.06.05 Added alodine finish TSR 1290 NG	
Est Rev F Added Rev.A 1 07-11-01 DD	
Est Rev:G now water jet 07-11-12 DD verified by EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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H705

Comment: Qty.: 0.0941 sf(s)/Unit Total : 0.0941 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040) Batch M103321 HB 07-11-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2608 (Grain along 9.03, offset 10 deg)

Dwg Rev: A1

Prog Rev: A1

HB 07-11-13

05

2-Deburr if necessary

HB 07-11-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 07-11-13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



HB 07-11-13 (5)

Comment: SECOND CHECK

Date: Monday, 12/11/2007 9:42:49 AM
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Drawing Name: CONSOLE BRACKET (407I)

Job Number: 35492

Part Number: D2608

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D2608

SB 07/12/03 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9/12/06 (X5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HJ

07-12-07

(X5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/12/07 (5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 38

7/12/07 SP (5X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



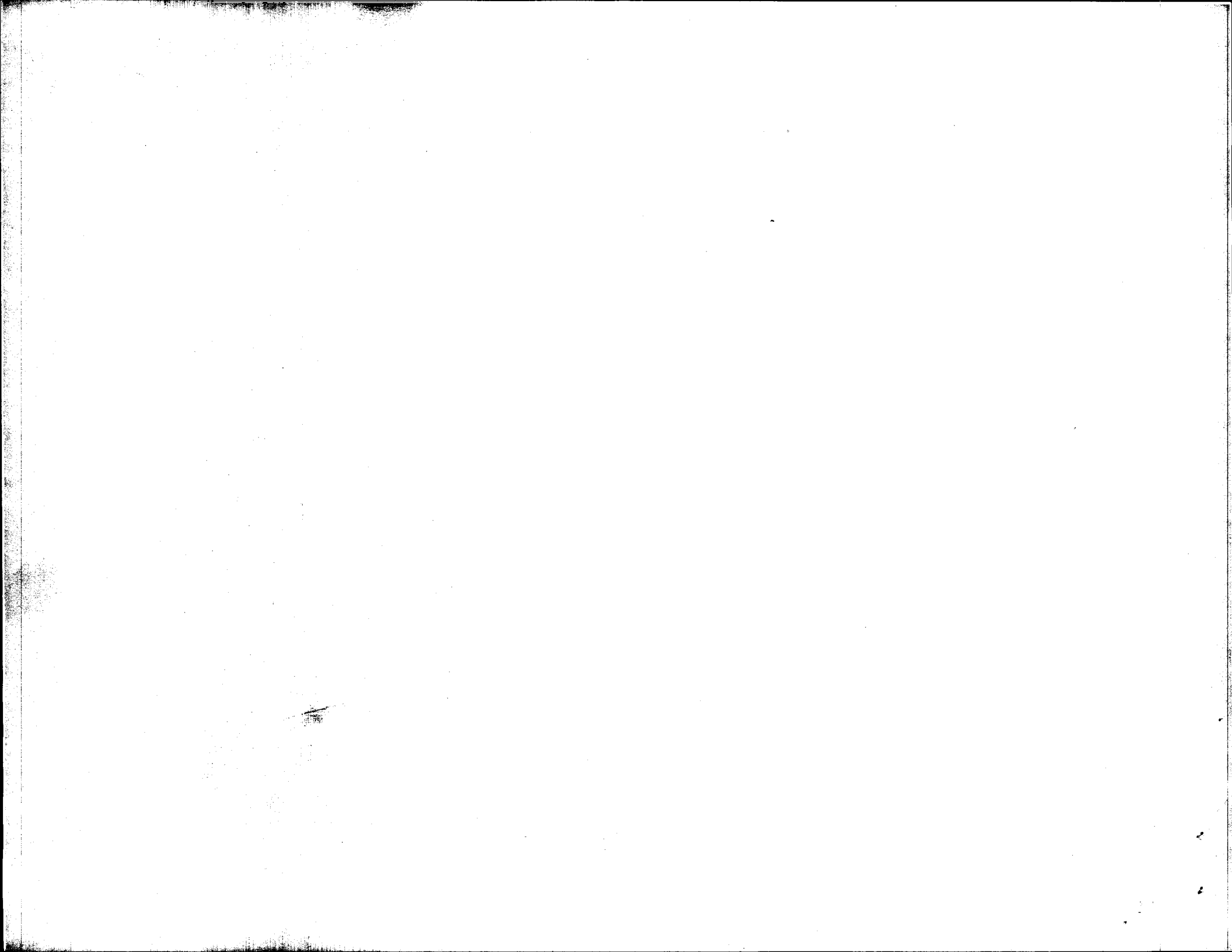
Comment: FINAL INSPECTION/W/O RELEASE

2007/12/11

Job Completion



mi 2007/12/11 CL



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE BRACKET (407)
Job Number	: 35492		
Estimate Number	: 11008		
P.O. Number	:	Part Number	: D2608
This Issue	: 10/31/2007 S.O. No. :	Drawing Number	: D2608 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: _____	Due Date	: 12/5/2007 Qty: 20 Um: Each
Checked & Approved By	: _____		
Comment	: Est. E 02.06.05 Added alodine finish TSR 1290 NG		

Job Number:

1.0 M2024T3S040 2024-T3 .040 sheet

Comment: Qty.: 0.0941 sf(s)/Unit Total: 1.8816 sf(s)
2024-T3 .040 sheet
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch _____

2.0 SHEAR SHEAR

Comment: SHEAR
Cut Blanks 1.891 X 9.03 (Grain along 9.03, offset 10°)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine per folio D2607

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK

Comment: SECOND CHECK

6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Deburr
Form as per Dwg D2608

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET (407I)

Job Number: 35492

Part Number: D2608

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

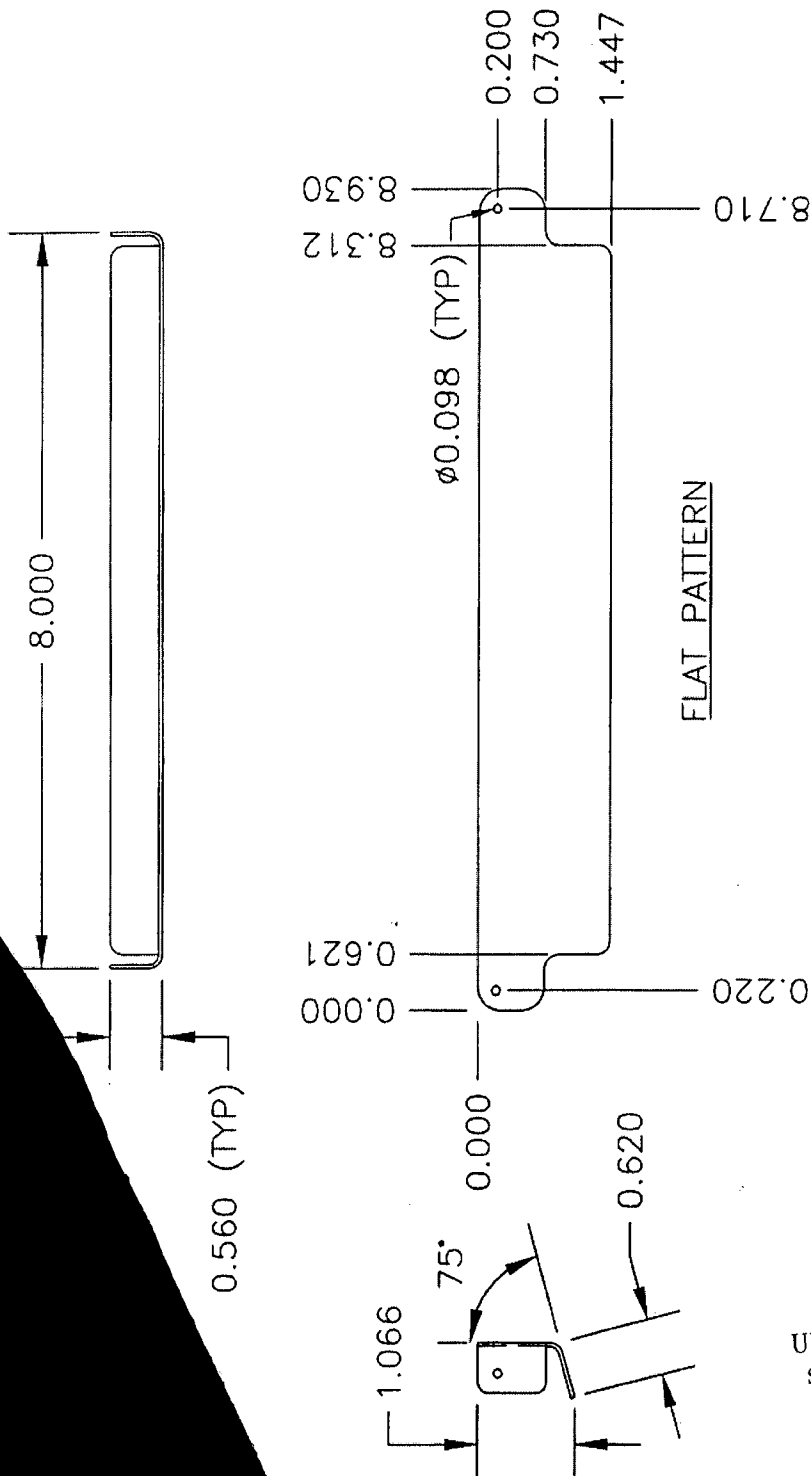
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY BW	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED A	DRAWING NO. D2608	REV. A SHEET 1 OF 1
DATE 97.10.23		TITLE CONSOLE BRACKET	SCALE 1:2
A	97.10.23	D2608 WAS D206-547-25	
AI	02.06.04	ADD FINISH	

RELEASED
97.11.04 KE

TSR A421



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35492

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2608
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI Q55 4.1 AI

